

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014971**Date Inspected:** 01-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b> Yes No N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b> Yes No N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b> Yes No N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b> Yes No N/A
				<b>Delayed / Cancelled:</b> Yes No N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	Orthotropic Box Girder( OBG)	

**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

Segment # 8AW

This QA Inspector performed Dimension Inspection along with Caltrans QA Inspector Mr.Surendra Prabhu Joint Survey Inspection for the following Segment 8AW from Panel Point 61 to PP 64.5

Corner Assembly Cope Holes dimension measurements at Typical Corner Assembly Survey Location is E1~ E2, S1 ~ S4, T1 ~ T3 Cope Hole Diameter from PP 61 to 64.5 Cross Beam and Counter Weight side.

Corner Assembly Cope Holes dimension measurements at Typical Corner Assembly at Intermediate Panel Point Survey Location is E1~ E2, S1 ~ S4, T1 ~ T2 Cope Hole Diameter from PP 61 to 64.5 Cross Beam and Counter Weight side. All these details noted and forwarded to team leader for further action.

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### Segment # 8BW

This QA Inspector performed Dimension Inspection along with Caltrans QA Inspector Mr.Surendra Prabhu Joint Survey Inspection for the following Segment 8BW from Panel Point 65 to PP 67

Corner Assembly Cope Holes dimension measurements at Typical Corner Assembly Survey Location is E1~ E2, S1 ~ S4, T1 ~ T3 Cope Hole Diameter from PP 65 to 67 Cross Beam and Counter Weight side.

Corner Assembly Cope Holes dimension measurements at Typical Corner Assembly at Intermediate Panel Point Survey Location is E1~ E2, S1 ~ S4, T1 ~ T2 Cope Hole Diameter from PP 65 to 67 Cross Beam and Counter Weight side. All these details noted and forwarded to team leader for further action.

### Segment # 8CW

This QA Inspector performed Dimension Inspection along with Caltrans QA Inspector Mr.Surendra Prabhu Joint Survey Inspection for the following Segment 8CW from Panel Point 68 to PP 71

Corner Assembly Cope Holes dimension measurements at Typical Corner Assembly Survey Location is E1~ E2, S1 ~ S4, T1 ~ T3 Cope Hole Diameter from PP 68 to 71 Cross Beam and Counter Weight side.

Corner Assembly Cope Holes dimension measurements at Typical Corner Assembly at Intermediate Panel Point Survey Location is E1~ E2, S1 ~ S4, T1 ~ T2 Cope Hole Diameter from PP 68 to 71 Cross Beam and Counter Weight side. All these details noted and forwarded to team leader for further action.

Please refer the Incident Report 04-0120F4\_TL-15\_B279\_05-24-10\_7EE-7DW\_Deck plate to Deck Plate flatness. Punch list item

Out of flatness was measured at 7mm using 600mm straight edge centered over the weld joint. Maximum deviation from flatness is 5mm measured over 600mm. Affected deck panel are Segment 7DE (DP495) to 7EE (DP 496).

ZPMC rectified the flatness after rectification check the flatness found satisfactory.

### 7AW Punch list item

Plumbness and Flatness measurement for Deck Panel to Deck Panel Diaphragm at PP 61, PP 62 and PP 63 East and West side of the Diaphragm.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Prabhune,Manoj	Quality Assurance Inspector
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<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer
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